



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2668-1

Job Sheet 208432



Part No: D2668-1

Job Qty: 4 pcs

Part Name: Saddle, LH, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/20

Job Tracking No:

Due Date: 4/13/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: D 02.03.15 Added DEO 9122 NG IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	4/13/20	4/13/20	1.00	9.14	HAAS - 1		SBL/DJP 20-04-18
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	4/13/20	4/13/20	0.00	9.14	Conventional Mill - 1 - B4B		DJP 20-04-18
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	4/13/20	4/13/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		



Container No: S271536



Part: D2668 - 1
Job No: 208432
Serial No/Batch: S271536
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Date: 04/17/20



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Date: 04/17/20

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					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	DIP 20-04-18
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
QC 8 - 3						
QC 8 - 32						
QC 8 - 33						
QC 8 - 35						
QC 8 - 39						
QC 8 - 4						
QC 8 - 44						
QC 8 - 45						
QC 8 - 49						
QC 8 - 58						
QC 8 - 8						
QC 8 - 9						
QC 8 - 68						
QC 8 - 67						
QC 8 - 1 (A)						
QC 8 - 47						
QC 8 - 40						
QC 8 - 52						
QC 8 - 23	10/4/18					
QC 8 - 57						
QC 8 - 76						
QC 8 - 61						
140 Handfinish - 1-1 Chemical-B4B	4 pcs	4/13/20	0.00 0.12	Handfinish - 1 - 1 - B4B	BER 20-04-20	
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
					Plex 3/19/20 2:50 PM Dart.lajeunesse.marie	

1254469.				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White Gl(A)-	4	4/13/20	0.00 0.14	Powdercoat - 1 - B4B	
B4B	pcs			Powdercoat - 2 - B4B	
START: 1230 OUT: 320° FINISH: 11:00				Powdercoat - 3 - B4B	20-04-20
160 QC 3	4	4/13/20	0.00 0.00	Powdercoat - 4 - B4B	
	pcs			QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	20-04-21
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
170 Packaging 3-1 - Stock - B4B	4	4/13/20	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	

					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS
					QC 21 - SA - 21	21
180 QC 21 - SA	4	4/13/20	0.00	0.00	QC 21 - SA - 70	9-38
	pcs				QC 21 - SA - 53	

51394

APR 21 2020

Part Op 100 - Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection
 Descriptions: last completed on _____ by _____ 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension
 Sheet 5-Machine Step No 2 of F

110 - Machine Keyway and inspect per attached dimension sheet

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 pcs (1 ea)	100-HAAS 4 Axis	3235965

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	4	32	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 208432
Description: 206 Saddle, Inboard, Left side		Part Number: D2668-1
Inspection Dwg: D2668	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.121	0.119	0.120	0.120	
B	0.100	0.140		0.126	0.125	0.125	0.125	
C	1.125	1.145		1.135	1.135	1.135	1.135	
D	0.615	0.685		0.655	0.658	0.658	0.658	
E	0.240	0.260		0.246	0.2465	0.246	0.246	
F	1.313	1.343		1.322	1.320	1.320	1.320	
G	0.210	0.220		0.219	0.219	0.220	0.220	
H	0.100	0.180		0.135	0.135	0.135	0.135	
I	2.470	2.510		2.492	2.494	2.494	2.494	
J	1.565	1.585		1.575	1.575	1.575	1.575	
K	0.235	0.240		0.238	0.238	0.238	0.238	
L	0.100	0.120		0.107	0.110	0.110	0.110	
M	0.990	1.010		1.003	1.003	1.003	1.003	
N	0.510	0.515		0.511	0.511	0.511	0.511	
O	5.990	6.010		6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.312	0.318		0.313	0.313	0.313	0.313	
S	0.315	0.322		0.316	0.316	0.316	0.316	
T	1.995	2.005		2.000	2.000	2.000	2.000	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		0.795	0.795	0.795	0.795	
W	1.040	1.060		1.049	1.050	1.049	1.049	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.922	0.922	0.922	0.922	
AA	0.490	0.510		0.500	0.501	0.499	0.500	
AB	0.178	0.198		0.188	0.188	0.188	0.188	
AC								
AD								
AE								
Accept/Reject								

Measured by: [Signature]	Date: 20-04-18
Audited by: [Signature]	Date: 20/4/19
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Revised dimensions R and Y	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					